

**Work Order ID 59839**

Friday, June 11, 2010 2:39:00 PM



Page 1

Item ID: D4021-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Hoop

Start Date: 6/11/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 10-6-14 Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4021

Prog Rev: BDwg Rev: B

Deburr as required

MAT NOT PULLED

10-6-15

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/06/21

130

0.00



Small Fab

Memo

0.00

Small Fab

1- make radius as per dwg  
2- deburr

= 7m.f 10/06/21

(6x)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/21

(x6)

W/O:		WORK ORDER CHANGES					
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Friday, June 11, 2010 2:39:00 PM



Page 3

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Item Name: Hoop

Stop



Start Date: 6/11/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Packaging

Identify as per dwg & Stock Location: WA

0.00

SAO 10-06-21

0.00

Memo

(6)

160



QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

Quality Control

10/06/23

10/06/22  
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Friday, June 11, 2010 2:39:04 PM

Page 1

Work Order ID: 59839



Parent Item: D4021-7



Parent Item Name: Hoop

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC  
per dwg REV.A DD 10.02.22 verified by:EC  
DD 10.04.20 verified by:EC

IPP Rev:B as  
IPP Rev:C as per dwg revB

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304B0.625X3.000		Purchased	No			100	f	0.5735	0.4166	2.631158			



304 BAR .625 X 3.00



1810-6-15

Location

Loc Qty

Loc Code

MAT53

0.5735

112320

0.5735

117320

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

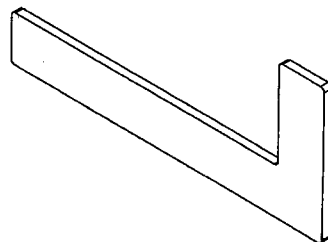
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

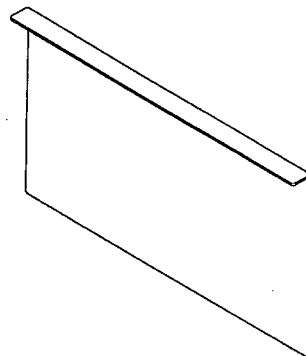
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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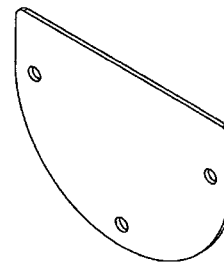




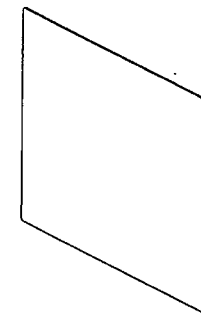
**D4021-1 HANDLE PLATE**



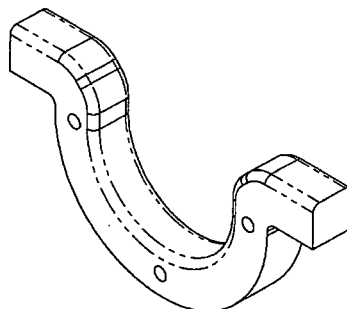
**D4021-3 DATA PLATE**



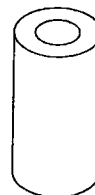
**D4021-5 BLANKING PLATE**



**D4021-11 INSTRUCTIONS PLATE**



**D4021-7 HOOP**



**D4021-9 BUSHING**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 59839

BS10-6-14

**RELEASED**  
2010-04-14

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

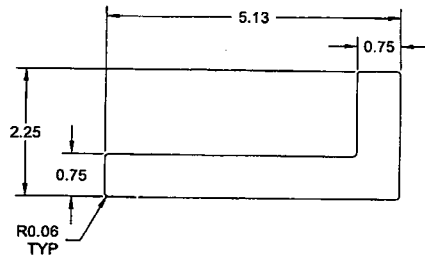
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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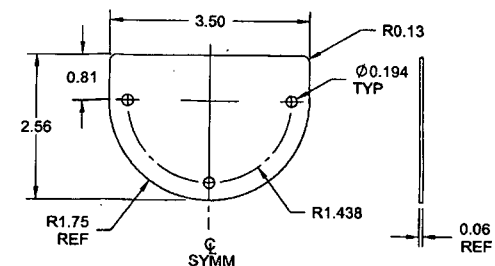
NOTE: Date & initial all entries



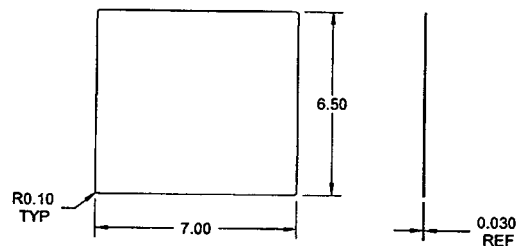
**D4021-1 HANDLE PLATE**



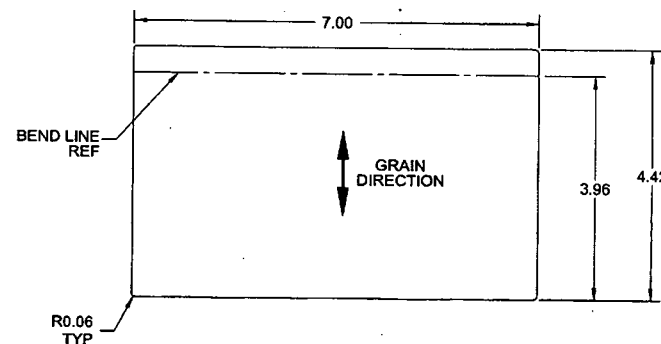
**D4021-3 DATA PLATE**  
MAKE FROM D4021-3F



**D4021-5 BLANKING PLATE**



**D4021-11 INSTRUCTIONS PLATE**



**D4021-3F DATA PLATE**  
FLAT PATTERN

**RELEASED**  
R 2010-04-14  
NP

**NOTES:**

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE  
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs  
-5: 0.14 lbs -11: 0.39 lbs

*u/o 39889*

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4021</b>	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MISC PARTS - 350 BASKET</b>	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

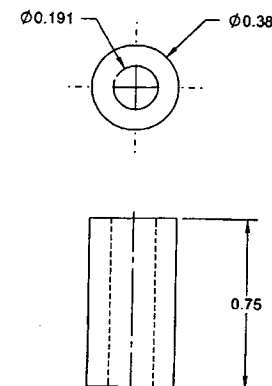
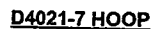
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D4021-9 BUSHING**

NOTES:

- NOTES:**  
 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
     REF DART SPEC M304B  
     -9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
     REF DART SPEC M304R  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT -7: 0.80 lbs  
     -9: 0.02 lbs

RELEASED  
2010-04-14  
MP

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4021</b>  TITLE <b>MISC PARTS - 350 BASKET</b>  SCALE <b>NTS</b>
DRAWN	JPH	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		REV. B SHEET 3 OF 3
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